

Work Order ID 86976

86976

Page 1

July-10-12 9:11:49 AM

Item ID: D3205-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Back Plate

Start Date: 7/10/12 Start Qty: 8.00

8

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 8.00

8

Customer:

Reference:

Run Start *NR1*

Approvals: Process Plan: MLJ Date: 12/07/11 Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3205	Rev B								

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

CUT AS PER DWG

6061 .250 X 2.00

PROG REV: B

DWG REV: _____

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

125

0.00

125

Mill Conv

Memo

0.00

Conventional Milling Machine

MILL CHAMFER

12-7-26

8

12-7-19

12-7-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Req'd Qty: 8.00

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Customer:

Reference:

Run Start ***NR1***

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop ***NR2***

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

127

QC2- Inspect parts off machine FAI/FAIB

0.00

12-7-26

8

127

QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

SMB 12-7-26

8

130

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

8

12-7-27

140

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
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July-10-12 9:11:49 AM

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N900040100

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Revision ID:

Stop *NS2*

Item Name: Back Plate

Start Date: 7/10/12 **Start Qty:** 8.00 ***8***

Cust Item ID:

Required Date: 8/10/12 **Req'd Qty:** 8.00 ***g***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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145

QC7-Inspect Chemical Conversion Coat

0.00

145

QC

Memo

0.00

Quality Control

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

150

Powdercoat

Memo

0.00

Powder Coating

START TIME: 11 OVEN TEMPERATURE:

FINISH TIME:

OVEN TEMPERATURE:

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 4

Item ID: D3205-3 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 8/10/12 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <i>GA</i> Memo	0.00 0.00				<i>8</i>			<i>[Signature]</i> <i>12/08/01</i>
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>12/8/11</i> <i>[Signature]</i> <i>MLJ 12/08/01</i>

W/O:		WORK ORDER CHANGES					
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Picklist Print

July-10-12 9:11:49 AM

Page 1

Work Order ID: 86976

Parent Item: D3205-3

Parent Item Name: Back Plate

Start Date: 7/10/12

Required Date: 8/10/12

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP B05.01.31 Revised Step 10KJ/JLM
23 JLM VERIFIED BY:EC

IPP REV:C AS PER REV B 12-03-

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X02.000 6061-T6 Bar .250 X 2.00		Purchased	No				f	49.7270		1.8315792		IB 12-7-19	

Location

Loc Qty

Loc Code

MAT001

49.727

107436

29.227

121836

0.5

122081

20

122081

W/O:		WORK ORDER CHANGES					
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Dart Aerospace Ltd

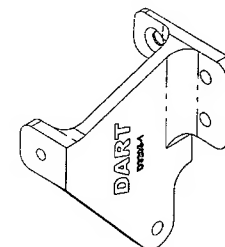
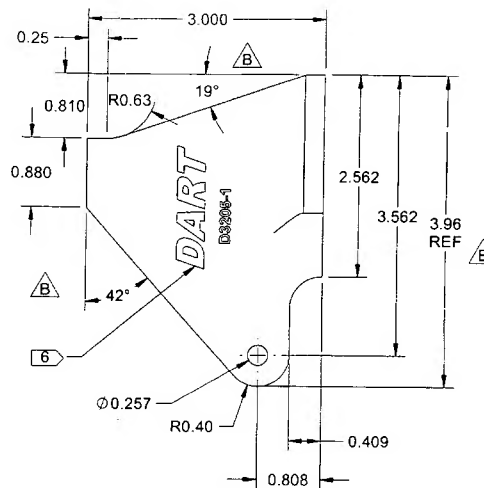
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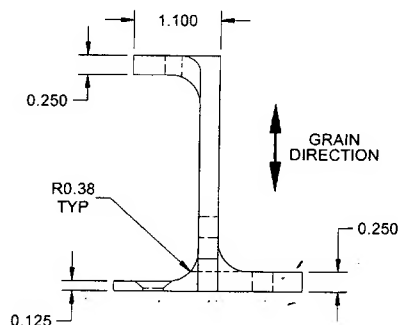
NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENTS
WITHOUT NOTICE
WORK ORDER

WORK ORDER
NO. 86976 MCL
12/07/11

RELEASED
2012-03-21
ECN 12-545 6P



B	CONVERT DRAWING TO STANDARD FORMAT; 3.96 WAS 3.99 (ZN C2-1); 19" WAS 18" (D3-1); 42" WAS 41" (ZN C4-1); CHANGE DIMENSIONS TO 2 DEC. PL (ZN D5-1, D6-1, C4-2, D5-2, C7-2); ADD CHAMFER (ZN D3-2); REMOVE ENGRAVING ON D3205-3		RF	12.02.24
A	NEW ISSUE		RF	04.01.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3205 TITLE BRACKET		
DRAWN	RF			
CHECKED	<i>[Signature]</i>		REV. 1 OF	
MFG. APPR.	<i>[Signature]</i>		SHEET 1 OF	
APPROVED	<i>[Signature]</i>		SCALE	
DE APPR.	<i>[Signature]</i>		NT:	
DATE	12.02.24		COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

- NOTES
- 1) MATERIAL: 7075-T73 ALUMINUM BAR
PER QQ-A-200/11 OR QQ-A-250/12
REF DART SPEC M7075/T73B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3,5,6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3
 - 7) WEIGHT: 0.28 lbs.

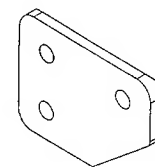
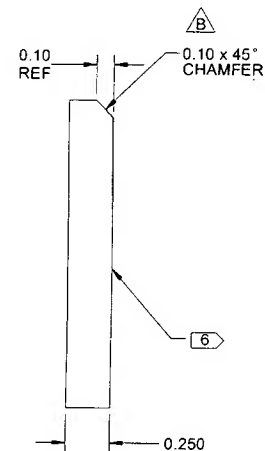
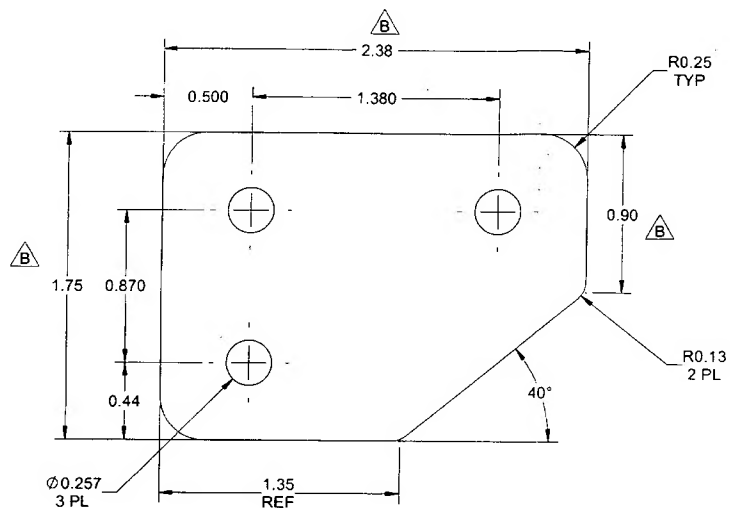
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86976

D3205-3 BACK PLATE

RELEASED
2012-03-21
ECN 12-545 CP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3205	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BRACKET	NTS
DATE	12.02.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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